

File 1
Work Order ID 70560



Page 1

Friday, June 10, 2011 3:43:58 PM

Item ID: D2672

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 13" X 24", 206

Start Date: 6/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: *11-06-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2672	Rev B1								

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D2672_BLANK

B 11-6-14

(9)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672
3-Deburr

F.K. / R 11-9-15

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

F.K. R 11-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70560

Friday, June 10, 2011 3:43:58 PM



Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

JL 11-09-16



Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

PMP 70560

0.00

11/9/16 (8)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/16 (8)

11-09-16 (8)

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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 3:44:07 PM

Page 1

Work Order ID: 70560



Parent Item: D2672

Parent Item Name: Bearpaw 13" X 24", 206


Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	300.6000	3.6	28.8	32.4 B11-6-14		

Location

Loc Qty

Loc Code

MAT018

300.6

117321

76.6

117738

59

117819

165

117819

9

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DART AEROSPACE LTD		Work Order:	76340
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	/		2x, 0.02	
B	12.750	+/-0.030	12.750	/			
C	4.250	+/-0.010	4.253	/			
D	2.000	+/-0.030	1.994	/			
E	9.000	+/-0.010	9.000	/			
F	0.375	+/-0.030	.380	/			
G	9.000	+/-0.010	9.000	/			
H	Ø0.260	+0.005/-0.000	.260	/			
I	Ø0.93	+/-0.030	.925	/			
J	0.300	+0.030/-0.000	.305	/			
K	0.625	+/-0.030	.635	/			
L	0.063 x 45°	+0.030/-0.010	.060	/			
M	0.250	+/-0.010	.247	/			
N	5.500	+/-0.030	5.502	/			
O	R0.250	+/-0.030	.250	/			
P	0.200	+/-0.030	.207	/			
Q	0.25 x 45°	+/-0.030	.25	/			
R	0.950	+0.030/-0.010	.960	/			
S	0.375	+/-0.010	.380	/			

Measured by: R. / FK	Audited by: JL	Prototype Approval:	N/A
Date: 11-9-	Date: 11-09-16	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

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SHOP COPY
RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

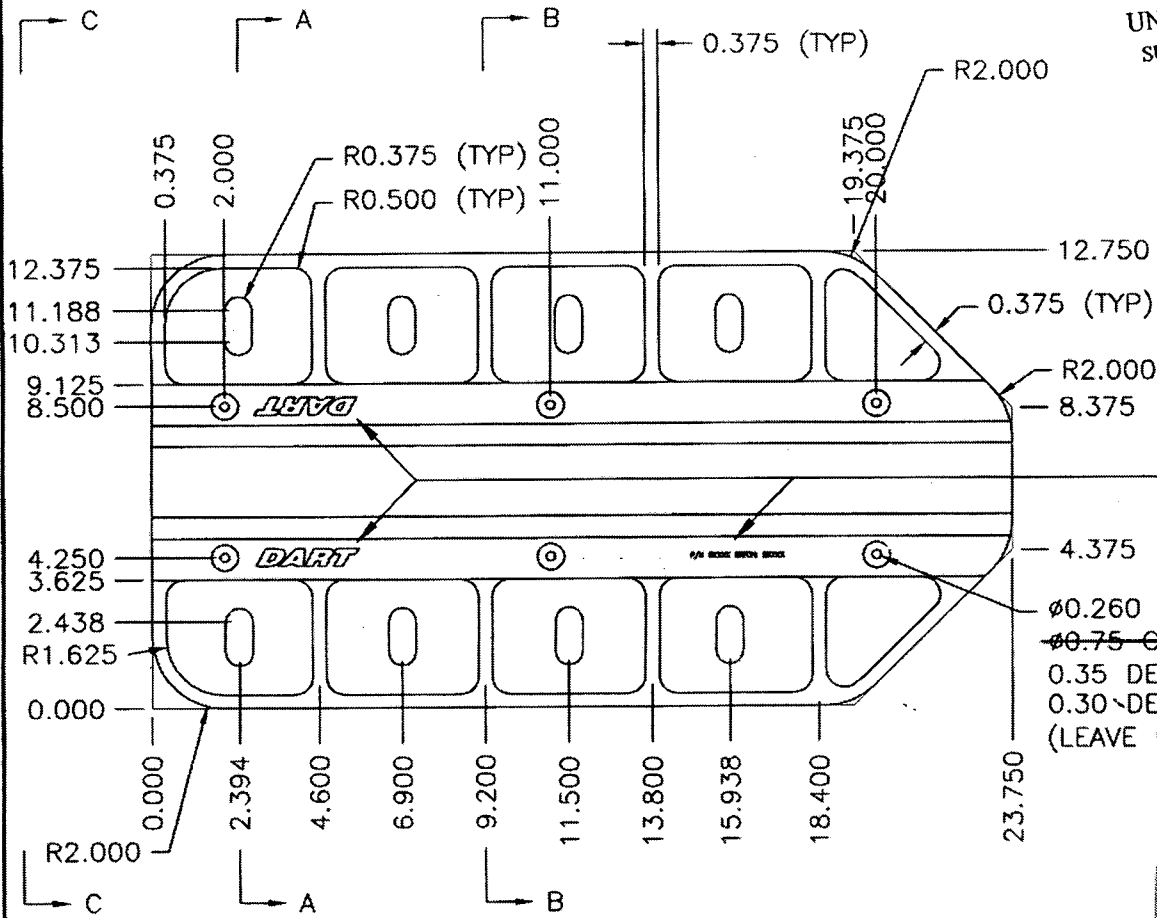
NO. 70560
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)



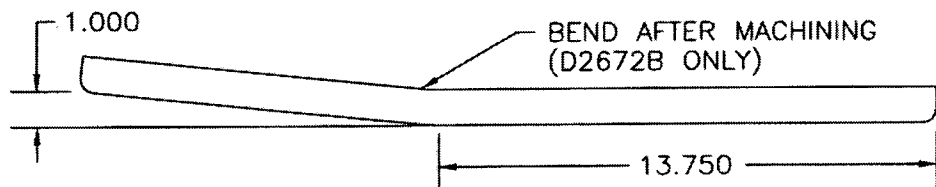
DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE		KE			
CHECKED		APPROVED		DRAWING NO.	REV. B
KE		KE		D2672	SHEET 1 OF 2
DATE			TITLE		SCALE
98.05.19			BEARPAW		1:5
A		97.04.08	NEW ISSUE		
B		98.05.19	CHANGE C'BORE. R1.58 WAS R1.50		
B1		98.06.17	CHANGE C'BORE. R1.58 WAS R1.50		

RELEASED
98.06.17 KE

EFFECTIVE	DEOS
9143	



FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

Copyright 1997 by DART AEROSPACE LTD

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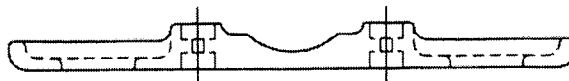
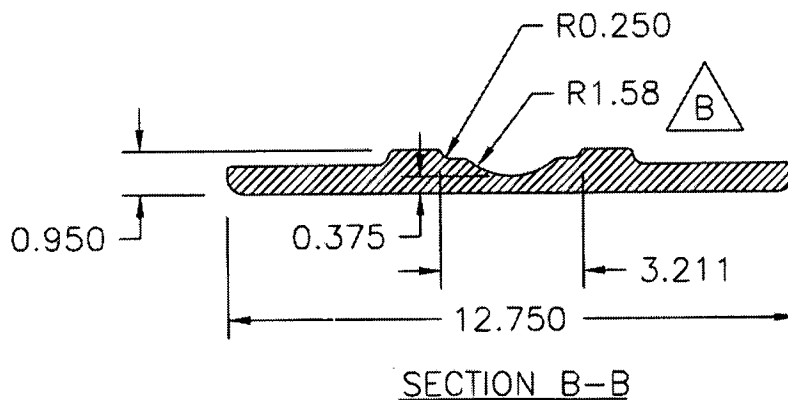
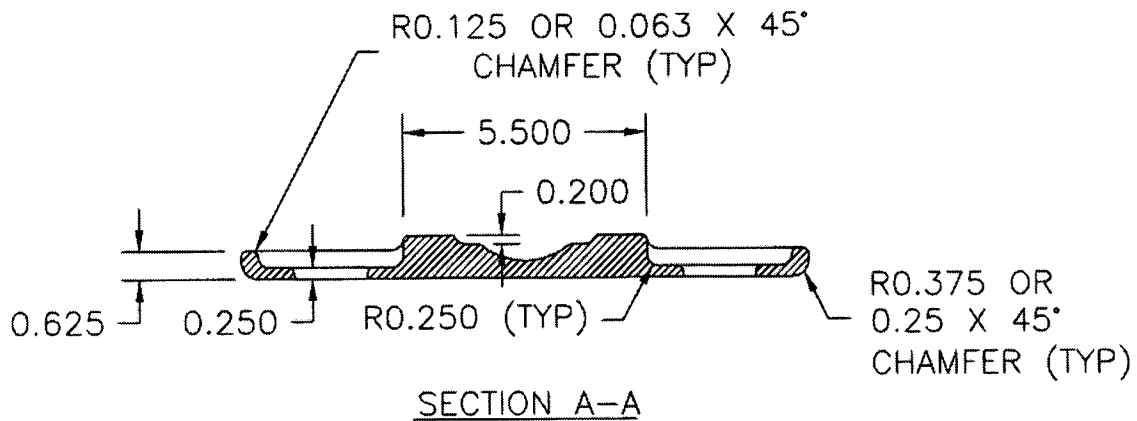
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE

u/v 70860



SECTION C-C

W/O:		WORK ORDER CHANGES					
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